



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2282-5

Job Sheet 186594



Part No: D2282-5

Job Qty: 60 ea

Part Name: Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPPRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	1/4/19	1/4/19	0.00	0.00	Start Up Machining		
100	Doosan	60 pcs	1/4/19	1/4/19	0.03	9.33	Doosan		
120	QC	60 pcs	1/4/19	1/4/19	0.00	0.00	QC8		
130	Packaging	60 pcs	1/4/19	1/4/19	0.00	0.00	Packaging3		
140	QC21-SA	60 Ea	1/4/19	1/4/19	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg D2282 and Folio FA189
Descriptions: 130 - *****STOCK IN LARGE FAB*****

21 NOV 28 2018
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	10.8036 ft (.18006 ea) 12.1800 207ea	90-Start up Operation	5116714 5110500

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R0.750	11	150	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.170Inches ± 0.030	2.200 2.140	2.169	
2	Handle Tube	0.063Inches ± 0.010	0.073 0.053	Radius	R .0625
3	Handle Tube	0.063Inches ± 0.010	0.073 0.053	.0625	
4	Handle Tube	0.125Inches ± 0.010	0.135 0.115	.127	
5	Handle Tube	0.090Inches ± 0.010	0.100 0.080	.092	
6	Handle Tube	45.000Degrees ± 0.000	45.000 45.000	45 Angle	
7	Handle Tube	0.350Inches	0.360	Radius	R .350

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

			+ 0.010	0.350	
			- 0.000		
8	Handle Tube	0.158Inches	± 0.010	0.168 0.148	.156
9	Handle Tube	0.386Inches	+ 0.005 - 0.000	0.391 0.386	Diameter .387
10	Handle Tube	0.700Inches	± 0.010	0.710 0.690	Diameter .700

Plex 11/19/18 12:50 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
--------	---------	-----------------	-----------------------

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

ULT CATEGORY	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
	Unqualified e/Unclear	